

Work Order ID 111161-2 ^{D 4712-043}

111161

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Thursday, January 09, 2014 11:35:38 AM

B 111161

Item ID: D4712-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket Assembly

Start Date: 1/9/2014 Start Qty: 8.00

8

Cust Item ID:

Required Date: 1/24/2014 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: PL Date: 1/1-01-9 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4712	C								
100	Pick Kit FLOW WATER JET	0.00							
100									
Packaging	Memo	0.00							
Packaging									
110		0.00							
110									
Small Fab	Memo	0.00							
Small Fab	ASSEMBLE AS PER DWG								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

NIA

MCS

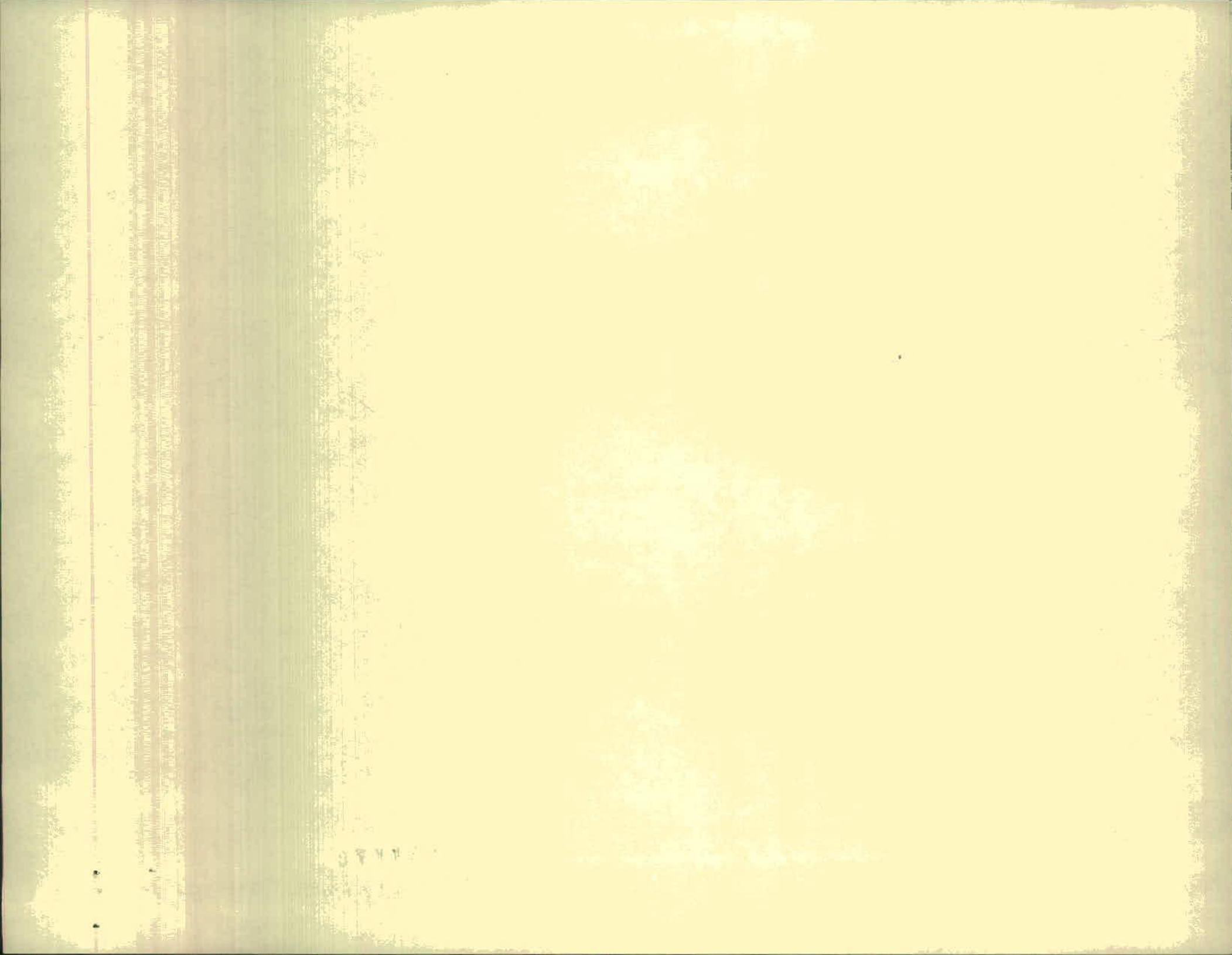
9x

14/01/23

DAS
36
9-89

DAS
27
9-89
14/1/23

9



Work Order ID 111161

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Page 2

Item ID: D4712-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 1/9/2014 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 1/24/2014 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>5T120</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

9x DAS 14-01-23
28
9-89
MLJ 14-01-24
14-01-24

Picklist Print

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Work Order ID: 111161

111161

Parent Item: D4712-043

D4712-043

Parent Item Name: Bracket Assembly

Start Date: 1/9/2014

Required Date: 1/24/2014

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.11.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4712-3		Manufactured	No			100	Each	0.0000	1	8			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D4712-3

Bracket

MS20426AD3-13

MS20426AD3-2

Rivet

Purchased No

100

Each

18,153.00

4

32

**

Location

Loc Qty

Loc Code

Mezz

18153

1173

8873

13276

9280

2350-18-C3Y

Purchased

No

100

Each

88.0000

2

16

**

2350-18-C3Y

Rigid Receptacle

Location

Loc Qty

Loc Code

ST395

20

19688

20

ST396

68

M126740

68

DAS
36
9-89

DAS
36
9-89

DAS
36
9-89

14/01/23

14/01/23

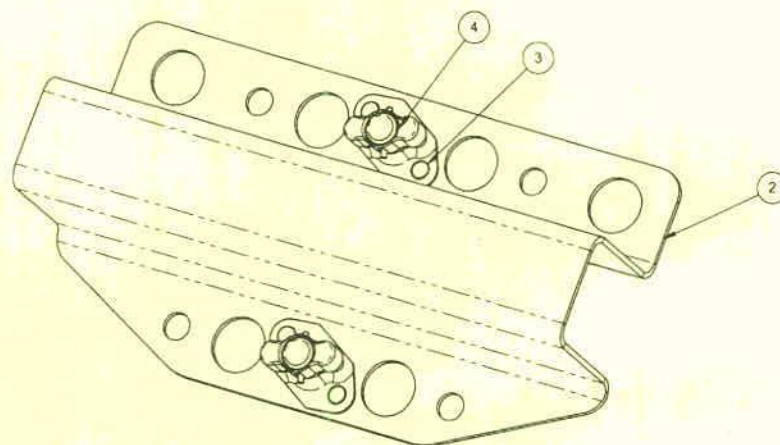
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14/01/23

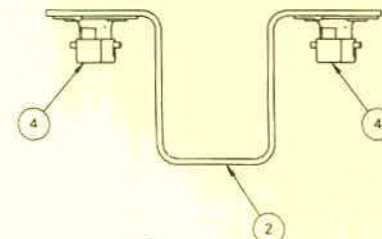
M127987

18x

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4712-043	BRACKET ASSEMBLY
2	1	D4712-3	BRACKET
3	4	MS20426AD3-2	RIVET
4	2	2350-18-C3Y	RIGID RECEPTACLE



D4712-043 BRACKET ASSEMBLY



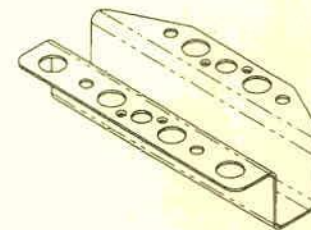
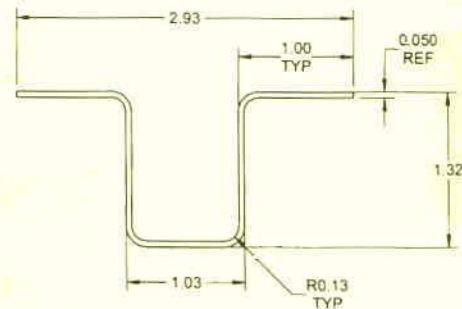
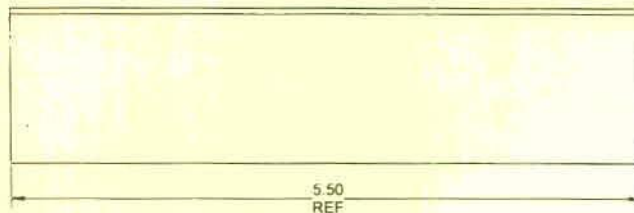
RELEASED
2013-12-23

ASS ECU 13-705

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.15 lbs

C	Φ0.129 WAS: Φ0.098 (ZN C4-3)	RF	13.09.11
B	REMOVED -041/-5, REMOVE CSK ON D4712-1F (ZN D4-3); Φ0.221 WAS Φ0.500 (ZN B4-3); REVISE D4712-3/-043 (ZN B4-4, B4-5)	RF	13.06.18
A	NEW ISSUE	RF	12.07.25
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO	REV. C
MFG. APPR.	DS	D4712	SHEET 1 OF 5
APPROVED	SA	TITLE	SCALE
DE APPR.		SUPPORT BRACKET ASSY	NTS
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D4712-3 BRACKET

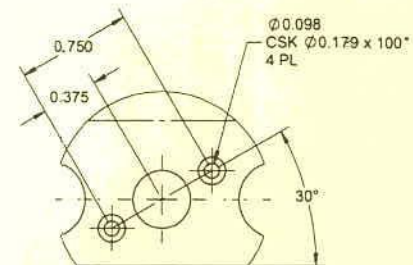
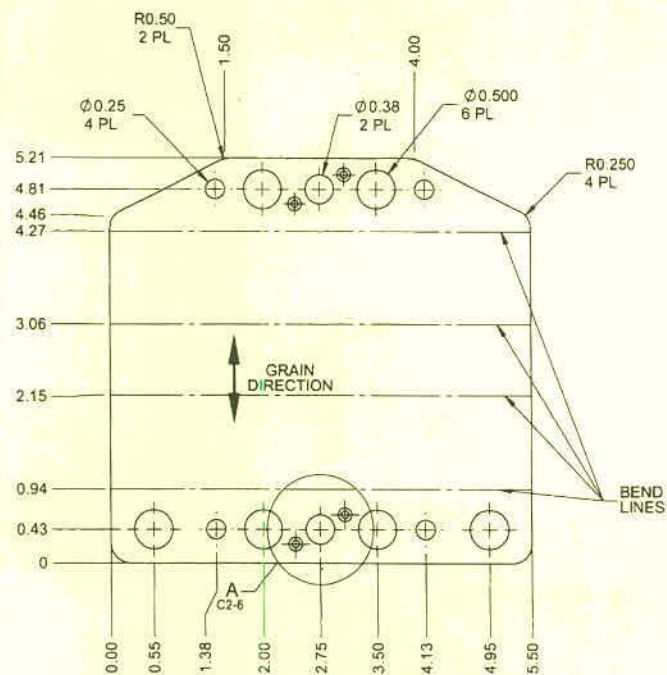
RELEASED
2013-12-23

ASS

NOTES:

- 1) MATERIAL: MAKE FROM D4712-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	JC	DRAWING NO.	REV. C
MFG. APPR	JD	D4712	SHEET 4 OF 5
APPROVED	JD	TITLE	SCALE
DE APPR	JD	SUPPORT BRACKET ASSY	NTS
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DETAIL A B6-6
2 PL D5-6

0.050
REF

D4712-3F FLAT PATTERN BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.050
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.13 lbs

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2013-12-23
A/S

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	DC	DRAWING NO.	REV. C
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